

ABSTRACT

METHOD FOR MAKING ALUMINIUM ALLOY STRIPS  
BY CONTINUOUS THIN GAUGE TWIN-ROLL CASTING

The invention concerns a method for making aluminium alloy strips containing (by weight) at least 0.15 to 1.5 % Fe and/or 0.35 to 1.9 % Mn, with  $\text{Fe} + \text{Mn} < 2.5 \%$  and optionally  $\text{Si} < 0.8 \%$ ,  $\text{Mg} < 0.2 \%$ ,  $\text{Cu} < 0.2 \%$ ,  $\text{Cr} < 0.2 \%$ ,  $\text{Zn} < 0.2 \%$ , and other elements each  $< 0.1 \%$  and  $< 0.3 \%$  in all, by continuous casting between two cylinders cooled and shrunk to a thickness ranging between 1 and 5 mm, the force applied to the cylinders during casting, expressed in tonnes per meter of strip width, being less than  $300 + 2000/e$ ,  $e$  being the cast strip thickness in mm. The invention also concerns strips in alloy of the same composition, twin-roll cast between 1 and 5 mm thick and having a product  $R_{0.2}$  (MPa)  $\times A$  (%) greater than 2500, and preferably than 3000.